

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015101**Date Inspected:** 22-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 8CW

ABF Request No: 06202010-3

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between bottom panel and side panel (Counter weight side) of OBG segment 8CW. Inspection was carried out on repair areas. The weld designations are as follows.

SEG047B-046 (OBG 8CW, B.P to S.P – Counter weight side)

ULTRASONIC INSPECTION

WELDING INSPECTION REPORT

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OBG SEGMENT 8AW

ABF Request No: 06222010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Cross beam side) of OBG segment 8AW. Inspection was carried out on repair areas. The weld designations are as follows.

SEG043*-044 (OBG 8AW, D.P to E.P – Cross beam side)

ULTRASONIC INSPECTION

CROSS BEAM # 14

ABF Report No: UT-CB14-003

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between bottom panel and side panel (West side) of cross beam # 14. The weld designations are as follows.

CB202A-014-017 (C.B #14, B.P to S.P – West side)

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

COUNTER WEIGHT # 48

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067665 performing Shielded Metal Arc Welding process for weld 023 located on PCMK CW001-PP048. ZPMC QC Mr. Wang Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-Repair-1. Weld repair report identified as B-WR13550.

OBG SEGMENT 8BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049769 performing Shielded Metal Arc Welding process for weld 012 located on PCMK SEG045A. ZPMC QC Mr. Shi Lei monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. Weld repair report identified as B-CWR1628.

OBG SEGMENT 9BE-9CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for weld 046 located on PCMK BP071-001. ZPMC QC Mr. Wu Zhi Zhang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 222396 performing Flux Cored Arc Welding process for weld 053 located on PCMK BP071-001. ZPMC QC Mr. Wu Zhi Zhang monitoring this

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welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
